

Date: Wednesday, 12/11/2008 1:40:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SEAT FRAME ASSEMBLY		
Job Number	: 43379			Part Number	: D3016041		
Estimate Number	: 11122			Drawing Number	: D3016 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/11/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 05/12/2008 Qty: 1 Um: Each		
Previous Run	: 42441						
Written By	:						
Checked & Approved By	: <u>JUL 08. 11/12</u>						
Comment	: Est. A 01.09.19 New issue EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NT0750W049	4130 RD Tube .750 x.049W	
		Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: <u>M103012</u>	
2.0	M4130NT1000W120	4130 RD Tube 1.00 x .120wall	
		Comment: Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s) 4130 Tube 1.0"D X 0.120"W batch <u>M108538</u>	
3.0	M4130NT0500W049	4130 RD Tube .500 x.049W	
		Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: <u>M106651</u>	
4.0	D301617	Gusset	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Gusset Pick: Qty Part Number Description Batch	
		2 D3016-17 Gusset <u>B39641</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:40:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 43379

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D301613

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
2	D3016-13	Bracket	<u>B34208</u>

108/11/20

6.0 D301615

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
2	D3016-15	Gusset	<u>B43413</u>

108/11/20

7.0 D30201

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
4	D3020-1	Fitting	<u>B36713</u>

108/11/21

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M19317

108/11/21

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BC 08/11/24 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:40:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 43379

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8001124 (1)

11.0

POWDER COATING

POWDER COATING



M 109 648



(1X)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME: 10:20

OVEN TEMPERATURE: 320

FINISH TIME: 10:50

M 1 08/11/24

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 43345

AS 08/11/24 (X)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 (X)

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

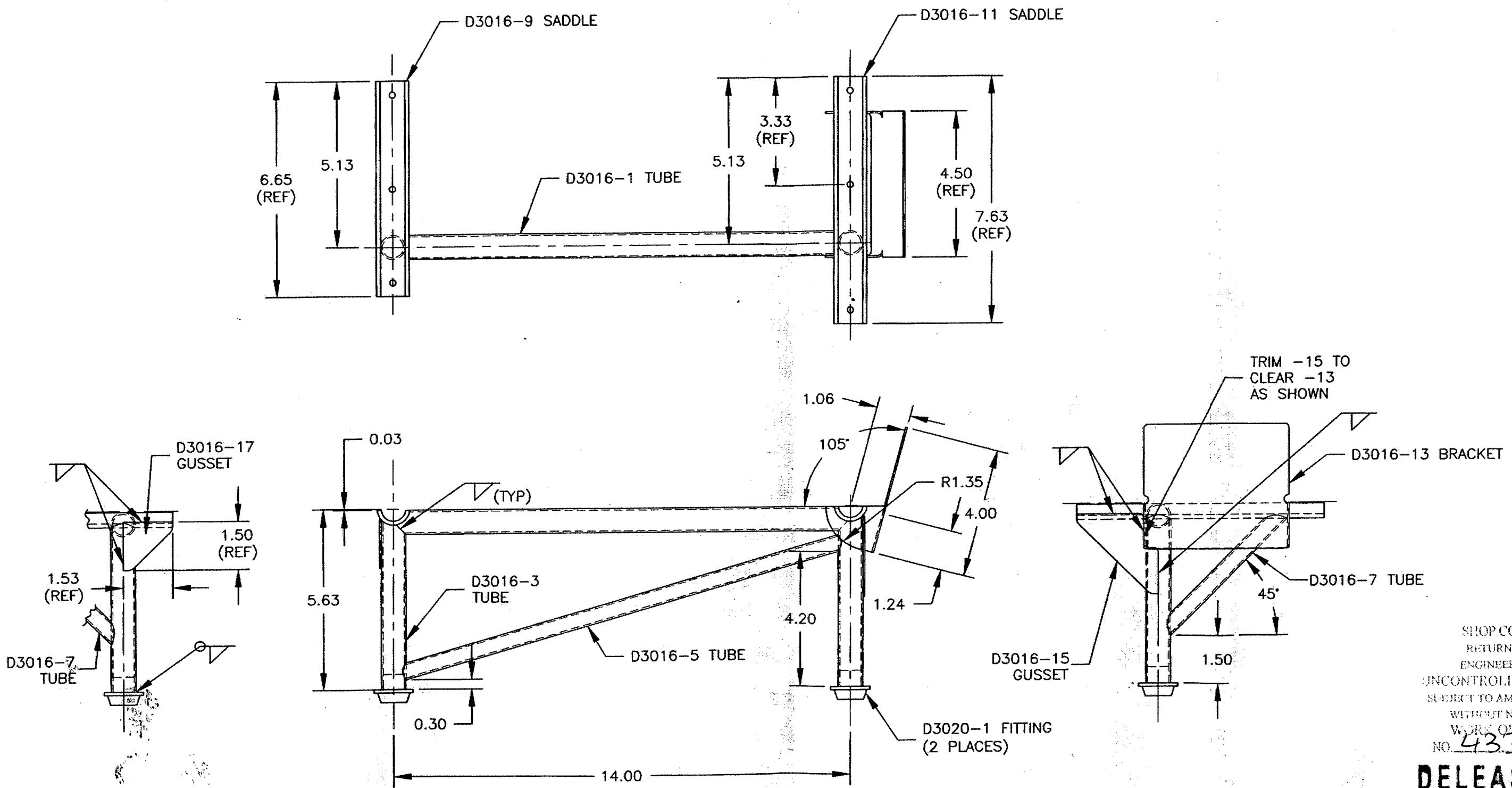
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WITHOUT NOTICE
WORK ORDER
NO. 43379

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01.05.18

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D3016-041 SEAT FRAME ASSEMBLY



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NO. 43379

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01.05.30

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	CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3016	REV. A SHEET 2 OF 3
	DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:3	

